



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

D3438-042
Job Sheet 175727



Part No: D3438-042

Job Qty: 2 ea

Part Name: Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP A 05.05.18 New Issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		4/12/18	0.00	0.00	Start Up Large Fab-4		DO 2018-04-10
100	Large Fab	2 pcs		4/12/18	0.00	2.56	Large Fab 2		SL
110	QC	2 pcs		4/12/18	0.00	0.00	QC9		MS 2018-04-13
120	QC	2 pcs		4/12/18	0.00	0.00	QC5		MS 2018-04-13
130	HandFinish	2 pcs		4/12/18	0.00	0.97	HandFinish1		SA 18-04-16
140	QC	2 pcs		4/12/18	0.00	0.00	QC3		CPC
150	Large Fab	2 pcs		4/12/18	0.00	2.56	Large Fab 2		SL
160	QC	2 pcs		4/12/18	0.00	0.00	QC10		DO 18-04-17
170	QC	2 pcs		4/12/18	0.00	0.00	QC5		DO 18-04-17
175	HandFinish	2 pcs		4/12/18	0.00	0.20	HandFinish6		SA 18-04-17
180	Powdercoat	2 pcs		4/12/18	0.00	0.28	Powdercoat1		BE 18-04-17
190	HandFinish	2 pcs		4/13/18	0.00	0.97	HandFinish3		BE DAS
200	QC	2 pcs		4/13/18	0.00	0.00	QC3		38
210	Packaging	2 pcs		4/13/18	0.00	0.00	Packaging3-1		9-89
220	QC21-SA	2 Ea		4/13/18	0.00	0.00	QC21		DAS 31 APR 18 2018

Part Op 100 - 1-Cut D2244 to 79.63" at 34° as per Dwg D3438 3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg
Descriptions: D3438 using DT8343 4-Grind
150 - Weld last cap per dwg D3438 & grind flush
175 - Touch up alodine
180 - 1-Touch up alodine
190 - Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs

M B8760 START: 9:15 OVT: 3:20 FINISH 9:45

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	5014552
D2561	Lug	4 Ea (2 ea)	90-Start up Operation	5041761
D2673-34	End Plate	4 Ea (2 ea)	90-Start up Operation	5042088
D2564	Mounting Angle	4 Ea (2 ea)	90-Start up Operation	5052121

Wing walk. M138761

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	2	154	0
	D2561	4	4	0
	D2564	4	15	0
	D2673-34	4	25	0
Part Specifications				
Specifications could not be found.				

Plex 4/10/18 1:04 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

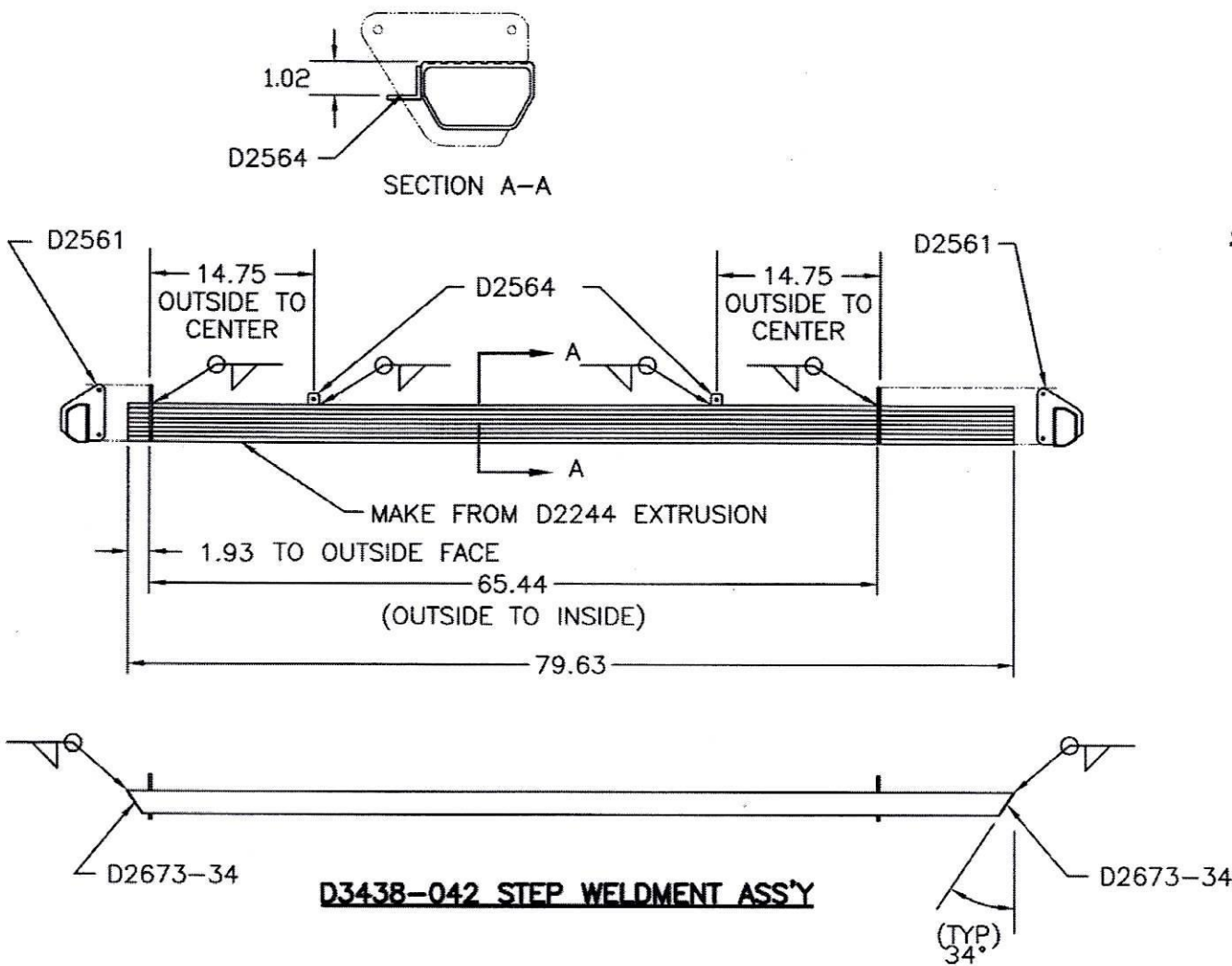
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART

RELEASED

05.05.22

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.09	DRAWING NO.	D3438	REV. A
		TITLE	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
A	05.05.09	NEW ISSUE		SCALE 1:1



NOTES:

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1 WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS



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Container No: S059714



Part: D3438-042

Job No: 175727

Serial No/Batch: S059714

Revision:

Inspector:

Date: 04/10/18